

Work Order ID 129065

129065

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Wednesday, January 28, 2015 9:06:01 AM

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 1/28/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/28/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1501-28 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3883	C

100	HAAS CNC VERTICAL MACHINING #1	0.00				12	Ø		DAS 20 9-89 15-03-04
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>129065</u> Double check by: <u>ML</u> 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets								DAS 44 9-89 15/03/05

110	QC2- Inspect parts off machine FAI/FAIB	0.00				12	Ø		DAS 20 9-89 15-03-04
110									
QC	Memo	0.00							
Quality Control									DAS 44 9-89 15/03/05

Work Order ID 129065

Wednesday, January 28, 2015 9:06:01 AM

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Page 2

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Outboard RH
Start Date: 1/28/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/28/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						12	0		JFC 2015-03-08
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						12	0		JM 15-3-11
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140						12	0	15-3-18	238
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:03 OVEN TEMPERATURE: 320 FINISH TIME: 12:30								

Wednesday, January 28, 2015 9:06:01 AM

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Reference:

Stop ***NR2***

MAR 18 2015

Packaging

0.00

Quality Control

DAS
27
9-29
AR 19 2015

MCS 150319

MF
15-3-10

Picklist Print

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Wednesday, January 28, 2015 9:06:04 AM

Work Order ID: 129065

129065

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 1/28/2015

Required Date: 1/28/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No				Each	8.0000		8			
D6101-015									**	DAS	44	15/03/02.	
Saddle Billet										9-89			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	5	
127518	5	
MAT045	3	
124323	3	
127518		
		10

DART AEROSPACE LTD		Work Order: 129065
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.642	.6415	.6415	.643		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.259	.259	.259	.259		
F	0.605	0.625		.609	.608	.6075	.608		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.0011	2.0016	2.0026	2.0023		
J	0.140	0.165		.145	.145	.144	.141		
K	0.240	0.260		.243	.241	.241	.241		
L	0.115	0.135		.126	.126	.126	.126		
M	0.140	0.165		.147	.145	.145	.144		
N	0.720	0.780		.755	.760	.760	.760		
O	0.240	0.260		.247	.244	.250	.250		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.865	2.865	2.865	2.865		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.002	1.002	1.003	1.003		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.499	.497	.500	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.216	.217	.217	.217		
AE	1.265	1.285		1.2668	1.267	1.268	1.268		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	DAS 20 9-89
Date:	15-03-03 / 15/03/05

Audited by:	JFC
Date:	2015-03-08

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	ILM
B	09.11.25	Dimension AE added	KJ	

DART AEROSPACE LTD		Work Order: 129065
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.648	.6435	.647	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.259	.259	.259	.259		
F	0.605	0.625		.613	.610	.612	.613		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.0033	2.003	2.003	2.005		
J	0.140	0.165		.143	.148	.149	.150		
K	0.240	0.260		.243	.247	.250	.250		
L	0.115	0.135		.127	.126	.125	.126		
M	0.140	0.165		.144	.148	.151	.154		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.251	.250	.251	.250		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.865	2.865	2.865	2.865		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.004	1.004	1.005	1.004		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.500	.500	.501		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.217	.217	.217	.217		
AE	1.265	1.285		1.269	1.269	1.2695	1.270		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	DAS 20	DAS 44
Date:	15-03-04	15/03/05

Audited by:	JFC
Date:	2015-03-08

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	ILM
B	09.11.25	Dimension AE added	KJ	

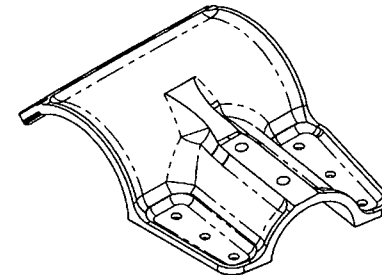
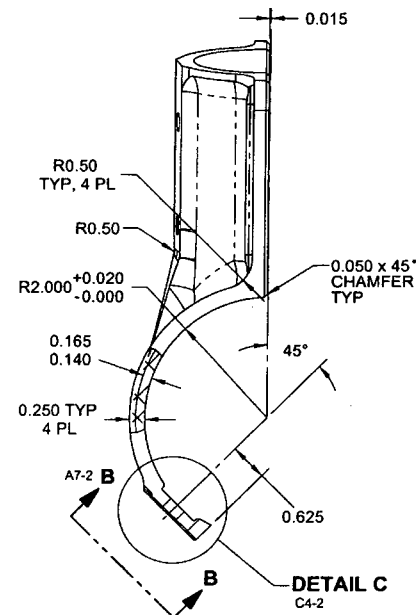
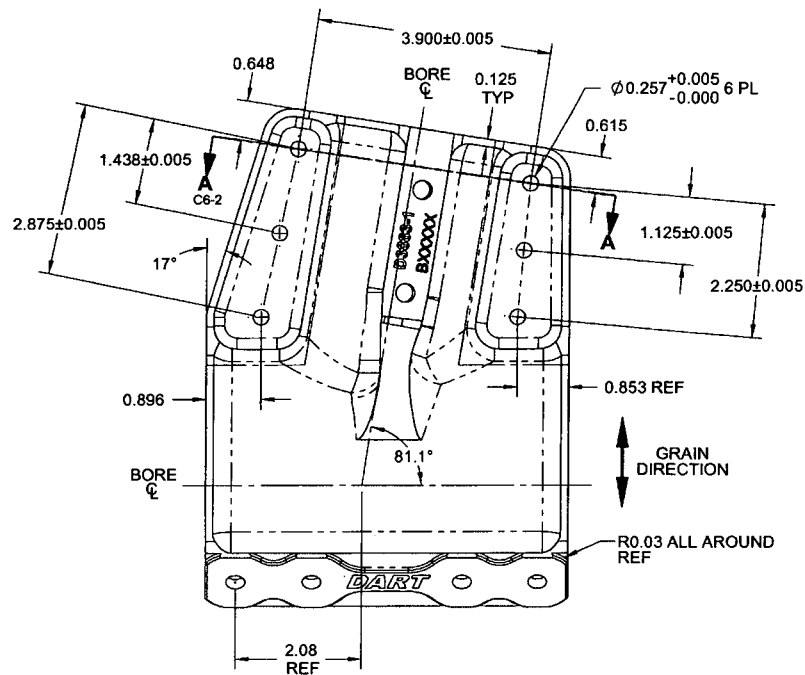
DART AEROSPACE LTD		Work Order:	129065
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9 #	10 #	11 #	12 #		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.646	.646	.647	.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.259	.259	.259	.259		
F	0.605	0.625		.615	.615	.613	.612		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.003	2.002	2.0015		
J	0.140	0.165		.149	.151	.152	.151		
K	0.240	0.260		.249	.249	.250	.250		
L	0.115	0.135		.127	.125	.124	.123		
M	0.140	0.165		.152	.154	.154	.154		
N	0.720	0.780		.760	.760	.760	.760		
O	0.240	0.260		.252	.251	.252	.253		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.865	2.865	2.865	2.865		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.004	1.005	1.006	1.006		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.500	.500	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.314	.314	.314	.314		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.217	.217	.217	.217		
AE	1.265	1.285		1.270	1.2685	1.2675	1.267		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	DAS	DAS	Audited by:	JFC
Date:	15-03-04	15/03/05	Date:	2015-03-08

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	ILM
B	09.11.25	Dimension AE added	KJ	



D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

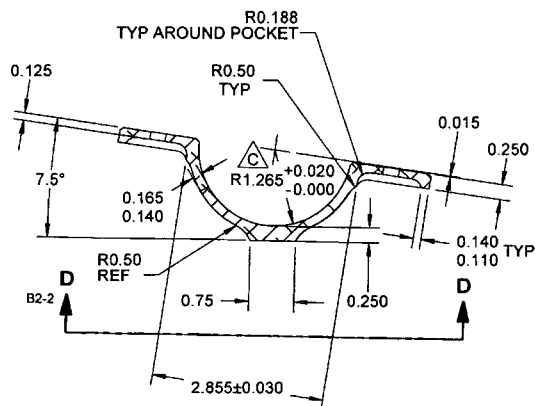
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.09		

DART AEROSPACE USA, INC.
 PORT HADLOCK, WA

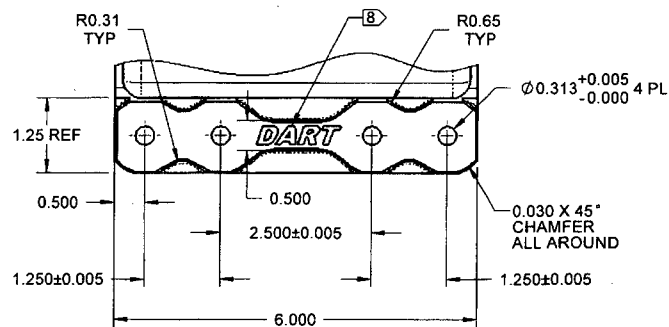
DRAWING NO. **D3883** REV. C
 SHEET 1 OF 2
 TITLE **OUTBOARD SADDLE** SCALE NTS

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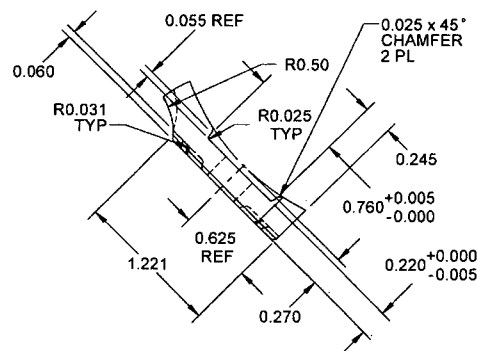
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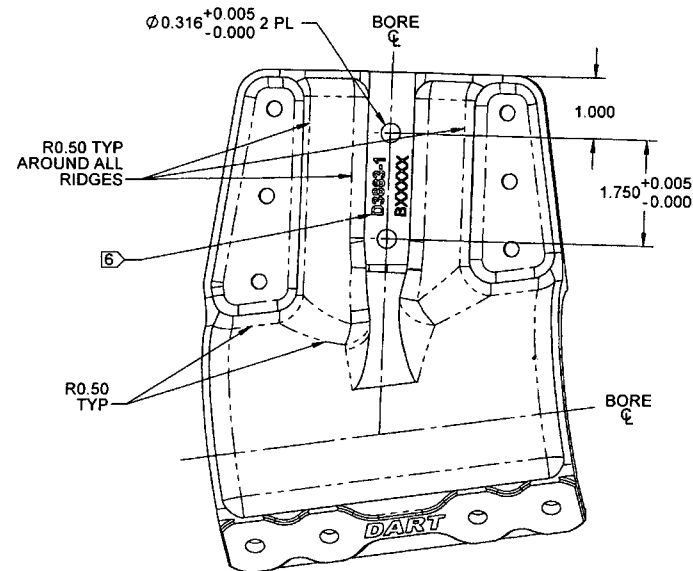
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X



VIEW D-D C7-2

RELEASED
2009-11-19
W

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3883	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	SCALE	
DE APPR.	<i>[Signature]</i>	OUTBOARD SADDLE	
DATE	09.11.09	NTS	

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